



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-748-203
Job Sheet 167169



Part No: D350-748-203

Job Qty: 1 ea

Part Name: AS350 / AS355 Stainless Steel Aft Crosstube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/25/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Air Methods Corporation (CAMET01)

7301 South Peoria Street Englewood, CO, 80112 USA ph:(303) 792-7400

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/14/17	0.00	0.00	Start Up Crosstubes	
110	CNC Bend Crosstubes	1 pcs		11/14/17	5.40	2.44	CNC Bend Crosstube	
120	Crosstubes	1 pcs		11/14/17	0.00	2.19	Crosstube	
127	QC	1 pcs		11/14/17	0.00	0.00	QC15	PD 12.11.2
128	Crosstubes	1 pcs		11/14/17	0.00	1.98	Crosstube	
130	Crosstubes	1 pcs		11/14/17	0.00	2.89	Crosstube	
140	QC	1 pcs		11/14/17	0.00	0.00	QC6	
174	Outsource	1 pcs		11/14/17	0.00	0.00	Outsource2	38263
176	Packaging	1 pcs		11/14/17	0.00	0.00	Packaging2	DAB 38
178	QC	1 pcs		11/14/17	0.00	0.00	QC5	38
180	SprayPaint	1 pcs		11/14/17	0.00	1.07	Spray Paint	ADAB NOV 11 2017
190	QC	1 pcs		11/14/17	0.00	0.00	QC14	38
200	Crosstubes	1 pcs		11/15/17	0.00	2.89	Crosstube	AR NOV 11 2017
210	QC	1 pcs		11/15/17	0.00	0.00	QC5	38
220	Packaging	1 pcs		11/15/17	0.00	0.00	Packaging1	38
230	QC	1 pcs		11/15/17	0.00	0.00	QC4	SMB
235	DC	1 pcs		11/15/17	0.00	0.00	DC	
240	Packaging	1 pcs		11/15/17	0.00	0.00	Packaging3	SMB
250	QC21-FG	1 Ea		11/15/17	0.00	0.00	QC21	21 NOV 21 2017

Part Op 110 - Bend tube as per Dwg D350-748-243 using CNC bender program D350A and Folio FT _____

Descriptions: 120 - ****VERIFY CROSSTUBE DIMENSIONS AS PER DWG****

127 - ***MARK CUT LINES***

128 - CUT TUBE AT HEIGHT ON FAI SHEET *twist = 0.136"*

130 - 2- Drill Tube as per Dwg D350-748-243 Using DT8876 Drill Jigs, 4- Engrave Part # and Batch # as per Dwg D350-748-243 5-Remove all marks from tube within limits of D350-748-243

174 - ISSUE P/O TO ACCUREN: *38263*

180 - ***VERIFY BY _____ BATCH # TO MATCH W/O *NOV 07 2017*

190 - Then, Wrap in plastic bag to protect from scratches

200 - INSTALL GROUND WIRE INSERT, THEN INSERT SCREW AND WASHER 2-Install supports with Proseal 890 per D350-748-243 and QSI 015 3-Install supports clamps Using Dt8876 as per Dwg D350-748-243, Torque to 60-80 IN-LBS.

210 - ***RE-CHECK TORQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

230 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

235 - Photocopy bluefile & type labels per PPPD350-748-201 CHG001

240 - Identify and pack for shipping as per PPPD350-748-203

cleaner 132520 Adhesion 138021 Primer 138046 Paint 138037

138408 exp 2/18

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

DISPOSITION Work Order: _____ Part No. _____ NCR No. _____ Date: _____	Suspecte Step #: _____ Description Work Order Deviation	AGAINST DEPARTMENT/PROCESS	neering Quality Other 042] Approval	leted By	I/ Supervisor I Verification	Coordinator proval	ied Wrong Dimensions nder tolerance orrect t/Missing ived ;	Sequence																																																																																																																																																																																																																																																																				
DART AEROSPACE S006021  AS350 / AS355 Stainless Steel Aft Crosstube Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																																																																																																																																																																																																																												
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PART NO: D350 - 748 - 203 Revision: Operation: SprayPaint Change No:																																																																																																																																																																																																																																																																												
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D350-748-243TRN	1	0	0	0
200-Crosstubes	AETC-1032	1	250	0	0
	D3502-1	2	80	0	0
	D5123-7	2	167	0	0
	MS21920-20	2	27	0	0
	NAS1149C0363R	1	221	0	0
220-Packaging	AN4-41A	8	185	0	0
	AN4-6A	16	751	0	0
	AN5-32A	4	130	0	0
	D3500-1	4	141	0	0
	D3501-1	16	946	0	0
	MS21042L4	24	967	0	0
	MS21042L5	4	488	0	0
	MS51958-63	1	84	0	0
	NAS1149D0463J	32	1,985	0	0
	NAS1149D0563J	8	1,766	0	0

Part Specifications

Specifications could not be found.

Plex 10/25/17 1:07 PM dart.poulin.maric

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

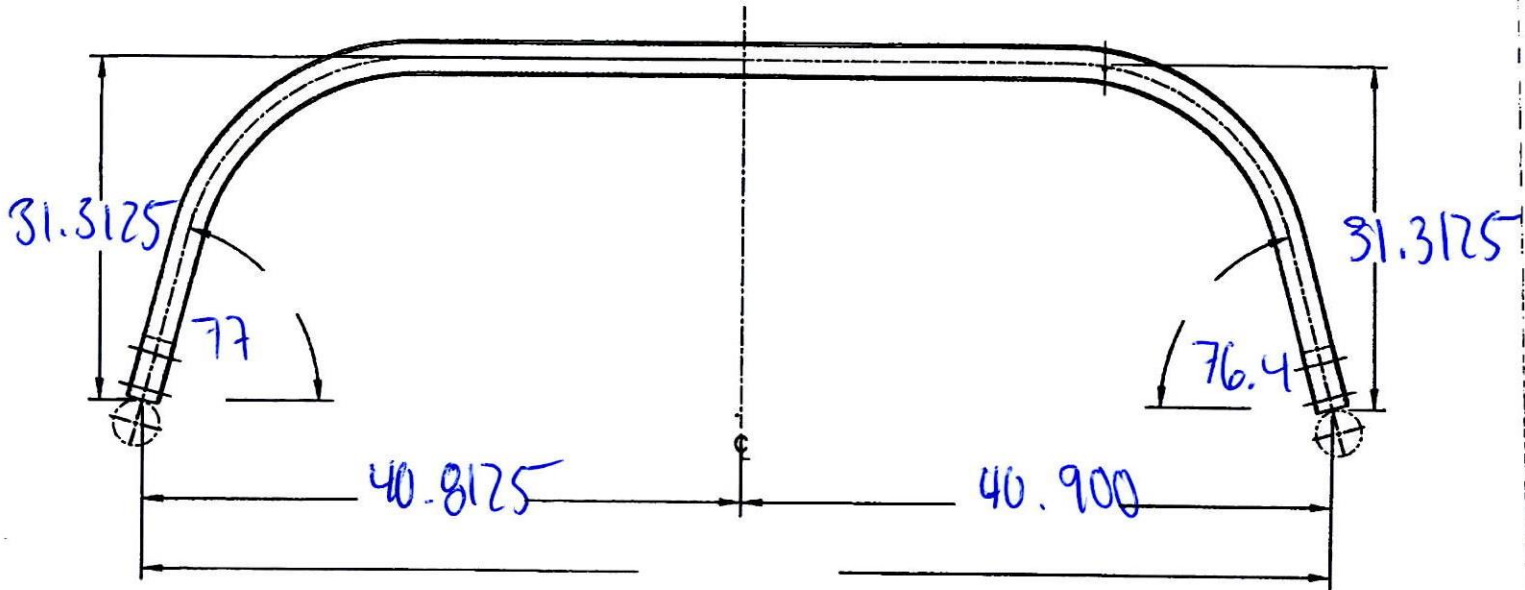
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	167169
Description: Crosstube High Aft, SS (AS350/355)		Part Number:	D350-748-203
Inspection Dwg: D350-748-243 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	31.10	31.60
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



	Side A	Side B
Bending Passes	34	34
Crushing	6%	6.1%
Comments		
Twist = 0.136"		

QC15 Inspection	PD
Date	17/11/2

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue	KJ	

Item	Qty -243	Part Number	Description
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20 OR MS21920-21/-22	CLAMP (PER DART SPEC. M-MS21920-20/-21/-22)
7	1	NAS1149C0363R	WASHER (OR AN960C10)
8	1	NAS1635-3-8	SCREW (OR MS51958-63)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.06 (AFTER BENDING/TRIMMING = 122.70 REF)
- FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 29.85 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.290 HOLE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- MAX AMPLITUDE OF RIPPING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- MAX TWIST: WITH TUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

- TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- TORQUE CLAMPS 80 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

DEO ATTACHED

RELEASED

2015 MAR 18

RELEASED

2015 MAR 18

UNDER REVIEW

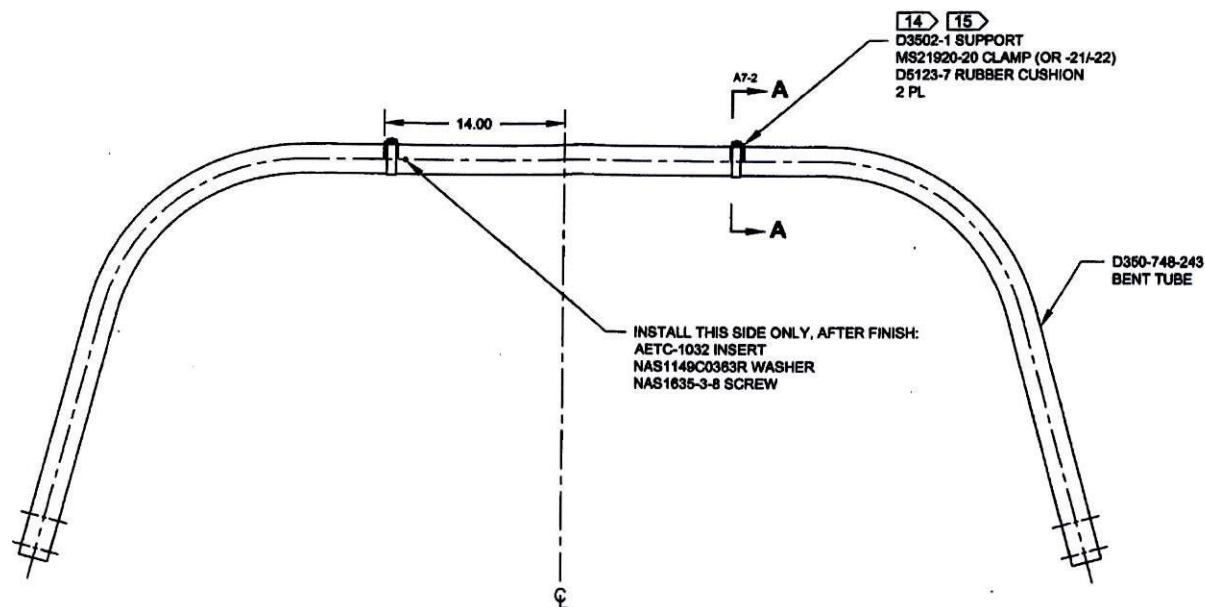
15/4/15
LRF 15/5/15
OK
9/16/25

A	NEW ISSUE	CP	15.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	15.01.21		

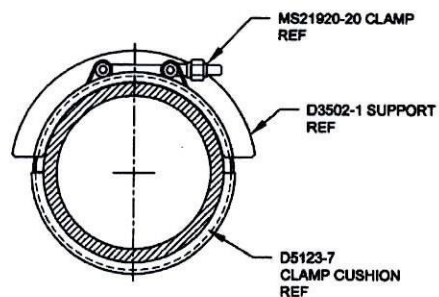
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D350-748-243
REV. A
SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI AFT)
SCALE NTS

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**D350-748-243
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 8X

DEO ATTACHED

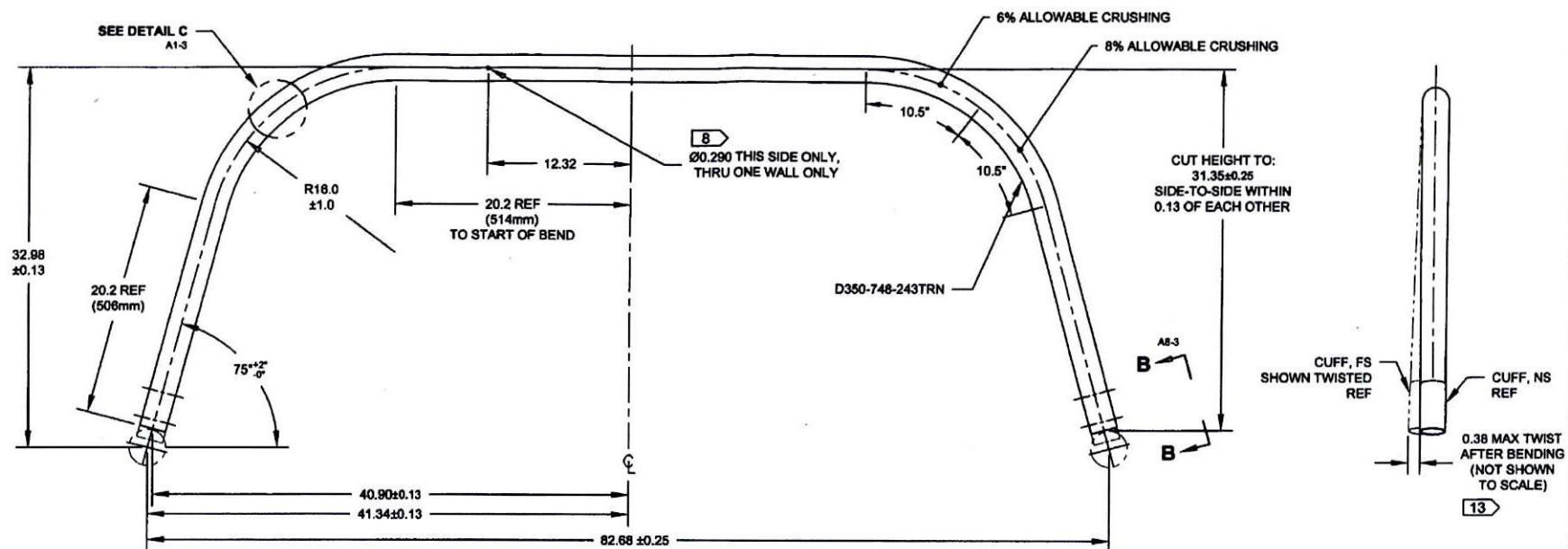
UNDER REVIEW

15/1/21 9/16/21

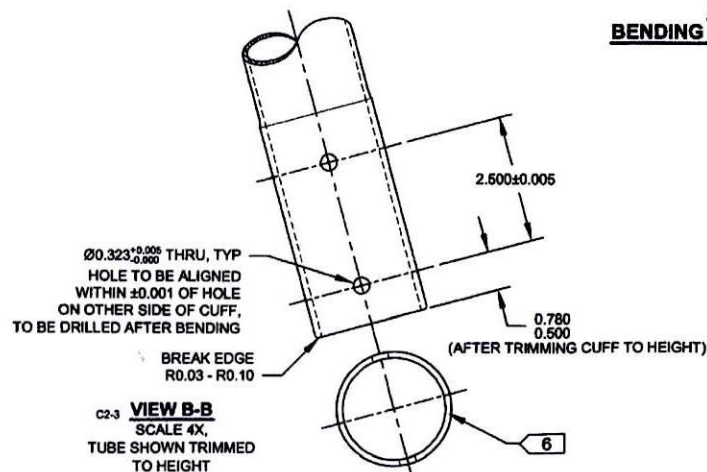
RELEASED

2015 MAR 18 97

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	7/1/21	D350-748-243	SHEET 2 OF 4
APPROVED	7/1/21	TITLE	SCALE
DE APPR.	7/1/21	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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D350-748-243
BENDING AND DRILLING DETAIL 11

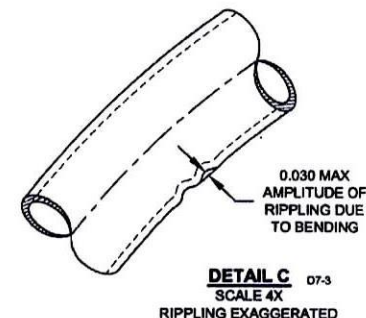


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RELEASED

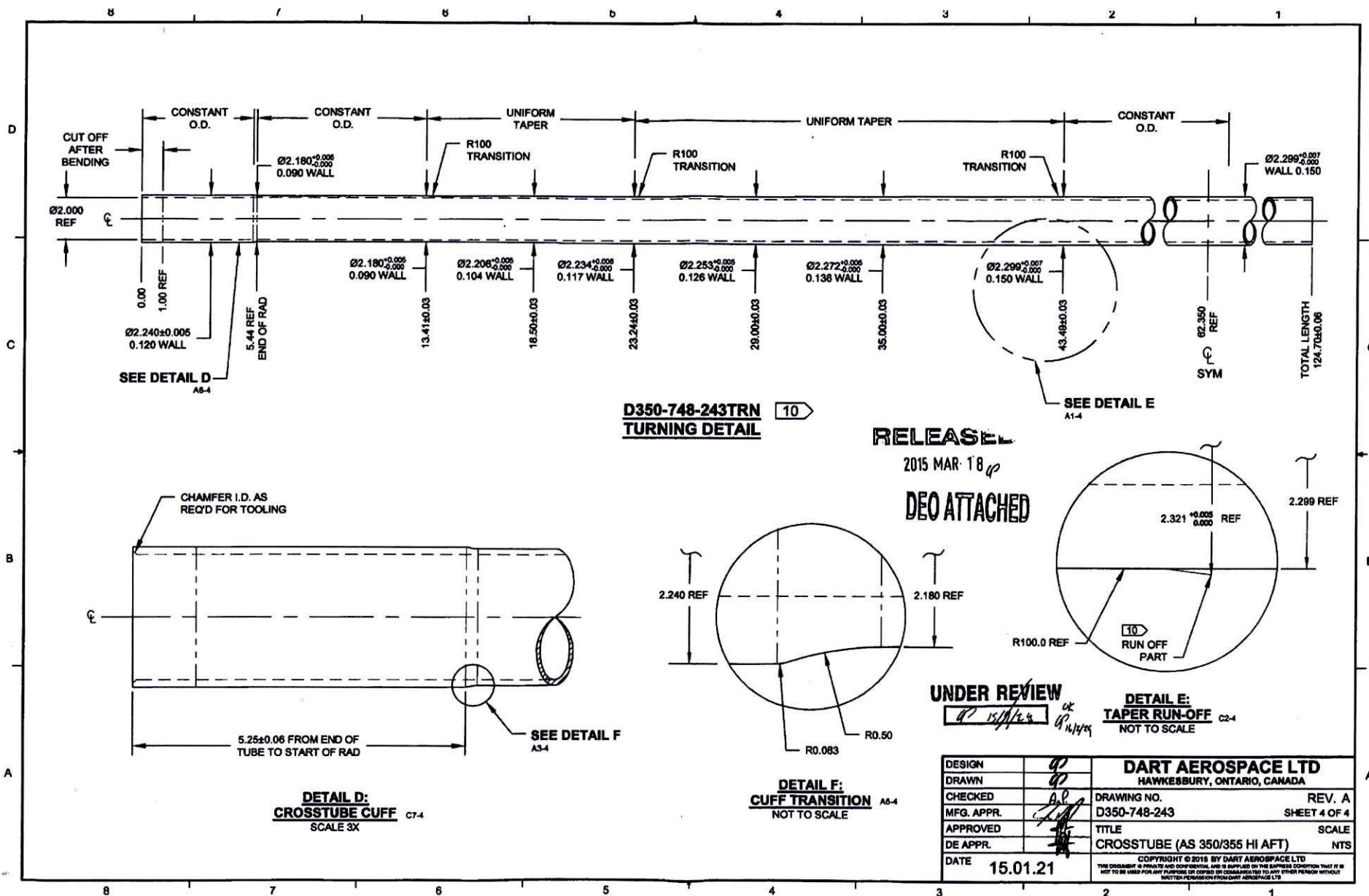
2015 MAR 18

UNDER REVIEW

15/1/12



DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D350-748-243	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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DRAWING NO.	D350-748-243	TITLE	REV. A	DART AEROSPACE LTD	D.E.O. NO.	D350-748-243-A-1	SHEET NO.	SCALE
DRAWN	15.11.18	CHECKED	15.11.18	MFG. APPR.	APPROVED	SHEET 1 OF 1	DE APPR.	NTS
DATE	15.11.18	DATE	15.11.18	DATE	15.11.18	DATE	15.11.18	DATE

AMEND NOTE 2 (SHEET 1) AS FOLLOWS:

2) FINISH: PREPARE SURFACE PER DART QSI 005 4.1.4
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
 OR
 POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

RELEASED
 2016-02-26
 EN 16-534

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO33887	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038263
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING FOUR (4) CROSSTUBES:

P/N: D350-748-103 S.S. FWD CROSSTUBE
1- JOB SHEET# 162594 2- JOB SHEET# 164727

P/N: D350-748-203 S.S. AFT CROSSTUBE
3- JOB SHEET# 164646 4- JOB SHEET# 167169

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-4) AS PER ASTM1417M-13						6 Nov 2017	
NO CRACK FOUND							
PEN (ZL-56, MPO13600), DEV. (SKD-S2, MPO11715), CLEANER (SKC-S, MPO19368)							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date: 6 Nov 2017
Name: CHRISTIAN BRIEN		



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038263

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038263
PO Date: 11/6/17
Due Date: 11/10/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	162594	D350- 748- 103	-	AS350 / AS355 Stainless Steel Fwd Crosstube ISSUE P/O TO ACUREN: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
2	164727	D350- 748- 103	-	AS350 / AS355 Stainless Steel Fwd Crosstube ISSUE P/O TO ACUREN: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
3	164646	D350- 748- 203	-	AS350 / AS355 Stainless Steel Aft Crosstube ISSUE P/O TO ACCUREN: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
4	167169	D350- 748- 203	-	AS350 / AS355 Stainless Steel Aft Crosstube ISSUE P/O TO ACCUREN: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$208.75/pcs	\$208.75
Grand Total:												\$835.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.